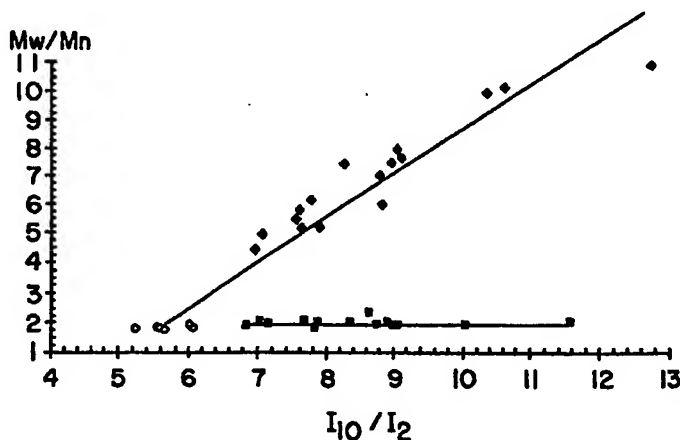




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(54) Title: MEDIUM MODULUS FILM COMPRISING SUBSTANTIALLY LINEAR POLYETHYLENE AND FABRICATION METHOD



- ♦ Linear Heterogeneous Polymer
- Substantially Linear Polymer
- Linear Homogeneous Polymer

(57) Abstract

Medium modulus polyethylene films with improved tear performance are made for heavy-duty packaging applications and hot-fill uses. Film compositions contain high molecular weight linear polyethylene and a substantially linear ethylene/ α -olefin interpolmer. The film is at least about 1.25 mils (31 microns) thick, has a film density in the range of 0.923 to 0.95 grams/cubic centimeter (g/cc) and typically has a tear strength or impact resistance at least 30 percent greater than current industrial polyethylene film. The novel film has good dimensional stability and strength properties which allow significant down-gauging savings.

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**MEDIUM MODULUS FILM COMPRISING SUBSTANTIALLY LINEAR
POLYETHYLENE AND FABRICATION METHOD**

5 This invention pertains to a medium modulus polyethylene film and a method for preparing such film. The novel film can be prepared by variable-stalk blown extrusion. The film has surprisingly high tear and impact properties. The film can be used in heavy-duty packaging and shipping applications and also in hot-fill packaging applications.

10 Polyethylene films with tear and impact properties are needed for packaging and shipping heavy items, such as building and construction materials, lawn and garden materials, salt, polymer pellets. Heavy-duty films and bags must also possess good rigidity and stiffness (modulus). Good film strength properties are required to prevent bag ruptures and
15 product losses during distribution while the rigidity and stiffness provide good dimensional stability. Dimensional stability is important during fabrication and packaging operations because it assists in maintaining the correct positioning of the film or bag as it is conveyed through the various equipment stations during bag-making and product-filling operational
20 steps. Dimensional stability at elevated temperatures during the product-filling step is also required in some instances when the product (for example, salt) is packaged hot such as, for example, in some form-fill-seal packaging operations.

 Heavy-duty packaging currently involves monolayer and multilayer
25 polyethylene films having a calculated film density as low as about 0.920 g/cc. Typical polyethylene film compositions for heavy-duty packaging include (a) blends of linear low density polyethylene (LLDPE) with low density polyethylene (LDPE), (b) high density polyethylene (HDPE) modified

by adding rubber and other elastomers (for example, polybutylene) to impart impact resistance, (c) LLDPE blended with a low molecular weight, high density polyethylene (LMW-HDPE), (d) LLDPE blended with a high melt flow rate HDPE, or (e) LLDPE blended with partially isotactic polymers.

5 See, for example, US Patent 5,041,401 by Shirodkar et al., US Patent 5,102,955 by Calabro et al. and US Patent 4,828,906 by Nishimura et al. Also known is the polyethylene composition disclosed by Thiersault et al. in US Patent 4,786,688 which contains 80 to 98 percent by weight HDPE and 2 to 20 percent by weight LLDPE which is alleged to be useful for thin film (20 microns) and

10 blow molding applications. Additionally, ternary polymer blends have been used in this packaging application. For example, in US Patent 4,824,912, Su et al. disclose LLDPE blended with minor amounts of a low molecular weight HDPE (LMW-HDPE) and a high molecular weight HDPE (HMW-HDPE) for processability and film property improvements over LLDPE used

15 alone.

The prior art shows that the linear ethylene polymers currently used in making polyethylene films provide increased tear strength as density increases to about 0.920 g/cc and then show substantially lower tear strengths as density increases above about 0.920 g/cc. Attempts to improve

20 tear strength by increasing film thickness have been only marginally effective. When film thickness is increased to improve strength properties, the rigidity of present art polyethylene films increases disproportionately to impact and tear resistance properties, and thereby thicker films offer practitioners little or no additional benefit. Thus, although a variety of

25 polyethylene films and film compositions are known, prior art polyethylene films are not completely satisfactory for use in heavy-duty packaging applications because they do not offer the desired balance of high tear and

impact resistance at the required film rigidity or modulus and/or they do not have the desired dimensional stability.

Hence, it is an object of the present invention to provide a polyethylene film with improved tear strength and impact resistance and good dimensional stability, as well as a method for making the same, which can be used in heavy-duty packaging and shipping applications and for use in hot fill packaging applications.

Applicants have discovered a novel medium modulus, polyethylene blown film having good impact and tear strengths, and a method for preparing such film. The novel film comprises:

- (A) from 60 to 95 weight percent, based on the combined weights of components (A) and (B), of at least one high molecular weight linear ethylene polymer having a density in the range of 0.92 to 0.96 g/cc and an I_5 melt index in the range of 0.1 to 3 g/10 minutes, and
- (B) from 5 to 40 weight percent, based on the combined weights of components (A) and (B), of at least one substantially linear ethylene/ α -olefin interpolymer characterized as having:
 - i. a melt flow ratio, $I_{10}/I_2 \geq 5.63$, and
 - ii. a molecular weight distribution, M_w/M_n , defined by the equation:

$$M_w/M_n \leq (I_{10}/I_2) - 4.63$$

wherein the substantially linear ethylene/ α -olefin interpolymer is further characterized as containing at least one α -olefin monomer and having a density in the range of 0.85 to 0.92 g/cc and an I_2 melt index in the range of 0.3 to 3 g/10 minutes.

The novel method for producing such medium modulus polyethylene film is a variable-stalk extrusion process which comprises the steps of:

- 5 (1) providing an extrudable thermoplastic composition containing (A) from 60 to 95 weight percent, based on the combined weights of components (A) and (B), of at least one high weight molecular linear ethylene polymer having a density in the range of 0.92 to 0.96 g/cc and an I_5 melt index in the range of 0.1 to 3 g/10 minutes, and (B) from 5 to 40 weight percent, based on the combined weights of components (A) and (B), of at least one substantially linear ethylene/ α -olefin interpolymer characterized as having:
- 10 i. a melt flow ratio, $I_{10}/I_2 \geq 5.63$, and
- ii. a molecular weight distribution, M_w/M_n , defined by the
- 15 equation:

$$M_w/M_n \leq (I_{10}/I_2) - 4.63$$

wherein the substantially linear ethylene/ α -olefin interpolymer is further characterized as containing at least one α -olefin monomer and having a density in the range of 0.85 to 0.92 g/cc and an I_2 melt index in the range of 0.3 to 3 g/10 minutes.

20

- 25 (2) introducing said composition of step (1) into a film extrusion apparatus equipped with an annular die,
- (3) extruding said composition of step (1) to form a tube that is subsequently blown-up and drawn-down through nip and take-off rollers to form a layflat film with a thickness greater than about 1.25 mils, and
- 30

- (4) conveying said film formed in step (3) for subsequent use down-line of the film extrusion apparatus of step (2) or collecting said film formed in step (3) for subsequent use off-line.

5 The film of the present invention has improved tear and impact performance that is not ordinarily expected for medium modulus, polyethylene films. The novel films have at least a 30 percent, and preferably 50 percent, improvement in impact and tear properties relative to prior art polyethylene films having about the same film density, melt index
10 and thickness. The benefit of the higher performing novel film is practitioners can now meet specified heavy-duty film requirements at substantially lower costs by down-gauging and/or by using higher diluent and recycled material loadings.

15 Figure 1 plots data describing the relationship between M_w/M_n and I_{10}/I_2 for three distinct polymer types: substantially linear polyethylene, heterogeneous linear polyethylene and homogeneous linear polyethylene.

Figures 2-4 are used to graphically summarize data presented in the Examples.

20 Figure 2 plots the relationship between tear strength and film thickness for Inventive Films and Comparative Films. Inventive Films are prepared from Film Compositions A, B and C and Comparative Films are prepared from Film Compositions D, E and F.

Figure 3 plots the relationship between impact resistance at 3 mils
25 and measured film density for Inventive Films and Comparative Films. Inventive Films are prepared from Film Composition G-J and P-V. Comparative Films are prepared from Film Compositions F, L, M and N.

Figure 4 plots the relationship between tear strength at 3 mils and measured film density for Inventive Films and both actual and predicted

Comparative Films. Inventive Films are prepared from Film Composition G, H and I. Comparative Films are prepared from Film Compositions E, F and K-O. The calculated or predicted tear strengths of comparative blend compositions are based on a 0.951 g/cc HMW-HDPE and a 0.870 g/cc SLEP at various ratios.

"Substantially linear ethylene polymer" (SLEP) herein designates an ethylene polymer having a polymer back-bone that is substituted with from 0.01 long chain branches/1000 carbons to 3 long chain branches/1000 carbons, more preferably from 0.01 long chain branches/1000 carbons to 1 long chain branches/1000 carbons, and especially from 0.05 long chain branches/1000 carbons to 1 long chain branches/1000 carbons.

"Long chain branching" is defined herein as a chain length of at least 6 carbons, above which the length cannot be distinguished using ^{13}C nuclear magnetic resonance spectroscopy. The long chain branch can be as long as about the same length as the length of the polymer back-bone.

Long chain branching is determined by using ^{13}C nuclear magnetic resonance (NMR) spectroscopy and is quantified using the method described by Randall (Rev. Macromol. Chem. Phys., C29, V. 2&3, p. 285-297).

The terms "ultra low density polyethylene" (ULDPE), "very low density polyethylene" (VLDPE) and "linear very low density polyethylene" (LVLDPE) have been used interchangeably in the polyethylene art to designate the polymer subset of linear low density polyethylenes having a density less than or equal to about 0.915 g/cc. The term "linear low density polyethylene" (LLDPE) is then applied to those linear polyethylenes having a density above about 0.915 g/cc.

The terms "heterogeneous" and "heterogeneously branched" are used herein in the conventional sense in reference to a linear ethylene/ α -olefin polymer having a comparatively low short chain branching

distribution index. The short chain branching distribution index (SCBDI) is defined as the weight percent of the polymer molecules having a comonomer content within 50 percent of the median total molar comonomer content. The short chain branching distribution index of

5 polyolefins can be determined by well-known temperature rising elution fractionation techniques, such as those described by Wild et al., Journal of Polymer Science, Poly. Phys. Ed., Vol. 20, p. 441 (1982), L. D. Cady, "The Role of Comonomer Type and Distribution in LLDPE Product Performance," SPE Regional Technical Conference, Quaker Square Hilton, Akron, Ohio,

10 October 1-2, pp. 107-119 (1985), or US Patent 4,798,081. Heterogeneous linear ethylene/ α -olefin polymers typically have a SCBDI less than about 30 percent.

The terms "homogeneous" and "homogeneously branched" are used herein in the conventional sense in reference to an ethylene/ α -olefin

15 polymer having a comparatively high short chain branching distribution index (SCBDI) as determined by well-known temperature rising elution fractionation techniques. Homogeneous ethylene/ α -olefin polymers typically have a SCBDI greater than or equal to about 30 percent.

The term "medium modulus" is used herein in reference to the

20 novel film to mean the calculated film density is in the range of 0.923 to 0.95 g/cc. The term "calculated film density" is used herein to mean the density of film when calculated from the known weight fractions and the measured annealed densities of the component polymers or layers.

The term "thick" is used herein in reference to the novel film to

25 mean a film thickness greater than about 1.25 mils (31 microns).

The term "variable-stalk extrusion" is a new term of art used herein to express the distance between the annular film die and stalk height or bubble expansion point which can be varied from 0 inches (0 centimeters) to

greater than 144 inches (366 centimeters) during blown film fabrication. The term includes both well-known pocket blown film extrusion and stalk blown film extrusion. The term "high stalk extrusion" is used herein in the conventional sense to mean a distance between the annular film die and
5 the air ring that is greater than or equal to 30 inches (76 centimeters). The term "low stalk extrusion" is used herein in the conventional sense to mean a distance in the range of 5 inches (12.7 centimeters) to 30 inches (76 centimeters).

The term "hot-fill" herein refers to a packaging or product-filling
10 operation where the product temperature is greater than 45°C. The term "heavy-duty" herein refers generally to industrial items packaged in bulk or having a single-package weight greater than 10 pounds (4.5 kilograms).

The density of the polymers used to make the medium modulus film of the present invention is measured in accordance with ASTM D-792 and is
15 reported as grams/cubic centimeter (g/cc). The measurements reported in the Examples below are determined after the polymer samples have been annealed for 24 hours at ambient conditions.

Melt index measurements are performed according to ASTM D-1238, Condition 190°C/2.16 kilogram (kg) and Condition 190°C/5 kg, and are
20 known as I_2 and I_5 , respectively. Melt index is inversely proportional to the molecular weight of the polymer. Thus, the higher the molecular weight, the lower the melt index, although the relationship is not linear. Melt index is reported as g/10 minutes. For purposes of this invention, in calculating certain values in the Examples, I_5 and I_2 values roughly relate to
25 one another by a factor of about 5.1; for example, a 1.0 I_2 index melt is equivalent to about a 5.1 I_5 melt index. Melt index determinations can also be performed with even higher weights, such as in accordance with ASTM

D-1238, Condition 190°C/10 kg and Condition 190°C/21.6 kg, and are known as I_{10} and $I_{21.6}$, respectively.

The term "melt flow ratio" is defined herein in the conventional sense as the ratio of a higher weight melt index determination to a lower weight determination. For measured I_{10} and I_2 melt index values, the melt flow ratio is conveniently designated as I_{10}/I_2 . For $I_{21.6}$ and I_{10} values, the ratio is designated $I_{21.6}/I_{10}$. Other melt flow ratios are occasionally used respecting polyethylene compositions, such as, for example, I_5/I_2 based on I_5 and I_2 melt index measurements. In general, $I_{21.6}/I_{10}$ and I_5/I_2 determinations provide similar melt flow values and I_{10}/I_2 values are usually greater than $I_{21.6}/I_{10}$ values by a factor of about 4.4 and this factor is used for purposes of this invention in calculating certain values in the Examples.

The tear resistance of the film of the present invention is measured in accordance with ASTM D1922 and is reported in grams. Tear resistance is measured both the machine direction (MD) and in the cross direction (CD). The term "tear strength" is used herein to represent the average between MD and CD tear resistance values and, likewise, is reported in grams. The impact resistance of the film of the instant invention is measured in accordance with ASTM D1709. Where indicated and according to the relationship of higher thicknesses yield increased performance values, tear and impact results are normalized to exactly 3 mils by proportionate increases or decreases based on actual measured (micrometer) film thickness; however, such normalization calculations are only performed and reported where thickness variations are less than 10 percent, that is, where the measured thickness is in the range of 2.7 - 3.3 mils.

The medium modulus, polyethylene film of the present invention has a calculated film density in the range of 0.923 g/cc to 0.95 g/cc,

especially, 0.926 g/cc to 0.948 g/cc, and more especially, 0.93 g/cc to 0.945 g/cc

The a film thickness is generally greater than about 1.25 mil, especially, in the range of 1.5 mil to 8.75 mils, and more especially, in the
5 range of 2 mils to 8 mils

These novel films have tear strength or, alternately, impact resistance, at least 30 percent greater than the tear strength or impact resistance of a comparative prior art polyethylene film having about the same film density, melt index and film thickness.

10 The tear strength of the novel film is also characterized by the following equation:

$$\text{tear strength (grams)} = Ax + Bx^2 + C$$

15 where A, B and C are numerical values and x is film thickness (mils); when A is less than or equal to about 150, B is greater than or equal to about 12.5, preferably greater than or equal to about 13.5, and more preferably greater than or equal to about 14.5; and when A is greater than about 150, B is in the range of -80 to 40, preferably -70 to 20, and more preferably -60 to 0. For
20 example, the expression $307.18x - 26.219x^2 - 98.134$ is thought to represent the tear strength of the film of the present invention, whereas the expression $138.22x + 4.8116x^2 - 19.364$ does not.

The strength of the novel film can be alternately characterized by the following equation:

25
$$\text{tear strength (grams)} = Ax^2 - Bx + C$$

where A, B and C are numerical values and x is measured film density (g/cc), wherein A is greater than or equal to 1.5×10^6 , preferably greater than or equal to 1.7×10^6 and B is greater than or equal to 2.75×10^6 , preferably greater than or equal to 3.0×10^6 . For example, the following expression is
30 representative of 30 percent greater tear strength than a comparative

polyethylene film having about the same melt index, film density and thickness:

$$\text{tear strength (grams)} = 1.565 \times 10^6(x^2) - 2.971 \times 10^6(x) + 1.41 \times 10^6.$$

5

The film can be even further or alternately characterized by the following equation:

$$\text{impact resistance (grams)} = Ax^2 - Bx + C$$

where A, B and C are numerical values and x is measured film density

10 (g/cc), where A is greater than or equal to 1.4×10^6 , preferably greater than or equal to 1.5×10^6 and B is greater than or equal to 2.5×10^6 , preferably greater than or equal to 2.75×10^6 . For example, the following expression is representative of 30 percent greater impact resistance than a comparative polyethylene film having about the same melt index, film density and
15 thickness:

$$\text{impact resistance (grams)} = 1.415 \times 10^6(x^2) - 2.676 \times 10^6(x) + 1.265 \times 10^6.$$

This novel film can be conveniently formed into bags and is useful in
20 heavy-duty packaging and shipping applications as well as in hot-fill packaging applications where films with a good property balance, that is, high strength and medium modulus with good tear, impact and dimensional stability, are needed.

The high molecular weight linear ethylene polymers, Component
25 (A), for use in preparing the medium modulus, polyethylene film of the instant invention are a known class of compounds which can be produced by any well-known particle-form polymerization process, such as slurry polymerization and gas phase polymerization. Preferably, the high molecular weight linear ethylene polymers are produced using well-known
30 Phillips or Ziegler type coordination catalysts, although metallocene catalyst systems can also be used. Although preferred, with conventional Ziegler

type catalysts, slurry polymerization processes are generally limited to polymer densities greater than about 0.940 g/cc and especially limited to polymer densities greater than about 0.935 g/cc, that is, about 0.935 g/cc is the practical lower commercial limit for slurry polymerization.

5 The high molecular weight linear ethylene polymer can be an ethylene homopolymer or a copolymer of ethylene with at least one α -olefin of from 3 to 20 carbon atoms. However, preferably, the high molecular weight linear polymer is a copolymer with at least one C_3 - C_{20} α -olefin, such as 1-propylene, 1-butene, 1-isobutylene, 4-methyl-1-pentene, 1-hexene, 1-
10 heptene and 1-octene. Most preferably, the high molecular weight linear ethylene polymer is an ethylene/1-butene copolymer prepared by a low pressure slurry polymerization process. The novel film comprises from 60 to 95 weight percent high molecular weight linear ethylene polymer, preferably 65 to 90 weight percent, and more preferably 70 to 85 weight
15 percent.

Component (A) can also be a blend of linear ethylene polymers. Such blends can be prepared in-situ (for example, by having a mixture of catalysts in a single polymerization reactor or by using different catalysts in separate reactors connected in parallel or in series) or by physical blending of
20 polymers.

The high molecular weight linear ethylene polymer has an I_5 melt index in the range of 0.1 g/10 minutes to 3 g/10, preferably, 0.1 g/10 minutes to 2 g/10 minutes and, more preferably, 0.15 g/10 minutes to 1 g/10 minutes. Additionally, the linear polymer preferably has a bimodal
25 molecular weight distribution (MWD) and an $I_{21.6}/I_{10}$ ratio in the range of from 1 to 12, preferably in the range of from 3.5 to 10, more preferably in the range of from 4 to 8, and most preferably in the range of from 4.5 to 6.

The high molecular weight linear ethylene polymer, which includes, but is not limited to, LLDPE, LMDPE and HDPE, and mixtures thereof, preferably has a density in the range of from 0.92 g/cc to 0.96 g/cc, more preferably, in the range of from 0.93 g/cc to 0.96 g/cc, and most preferably, in the range of from 0.935 g/cc to 0.958 g/cc.

The substantially linear ethylene/ α -olefin polymers used in the present invention Component (B), are a unique class of compounds that are defined in US 5,272,236 and US Patent 5,278,272 by Lai et al. Lai et al. teach that such polymers are preferably prepared by a continuous, solution phase polymerization process using the constrained geometry catalyst discovered by Stevens et al. US Patent 5,055,438. The substantially linear ethylene/ α -olefin interpolymers contain ethylene interpolymerized with at least one C₃-C₂₀ α -olefin, such as 1-propylene, 1-butene, 1-isobutylene, 1-hexene, 4-methyl-1-pentene, 1-heptene and 1-octene, as well as other monomer types such as styrene, halo- or alkyl-substituted styrenes, tetrafluoro-ethylene, vinyl benzocyclo-butane, 1,4-hexadiene, 1,7-octadiene, and cycloalkenes, for example, cyclopentene, cyclohexene and cyclooctene. Although the substantially linear ethylene/ α -olefin interpolymer can be a terpolymer where at least two α -olefin monomers are polymerized with ethylene, preferably the interpolymer is a copolymer with one α -olefin monomer copolymerized with ethylene and most preferably the substantially linear ethylene/ α -olefin interpolymer is a copolymer of ethylene and 1-octene.

Substantially linear ethylene/ α -olefin polymers are not the conventional homogeneously branched linear ethylene/ α -olefin copolymers described in US Patent 3,645,992 (Elston) nor are they the same class as conventional Ziegler polymerized linear ethylene/ α -olefin copolymers (for example, linear low density polyethylene or linear high density polyethylene made, for example, using the technique disclosed by

Anderson et al. in US Patent 4,076,698), nor are they the same as traditional highly branched LDPE. The substantially linear ethylene/ α -olefin polymers useful in this invention are indeed a unique class of polymers which have excellent processability, even though they have relatively narrow molecular weight distributions (typically, about 2). Even more surprisingly, as described in US Patent 5,278,272 by Lai et al., the melt flow ratio (I_{10}/I_2) of the substantially linear ethylene homopolymers or interpolymers can be varied essentially independently of the polydispersity index (that is, the molecular weight distribution, M_w/M_n). As Figure 1 illustrates, the rheological behavior of substantially linear ethylene polymers constitutes a dramatic contradistinction over to the homogeneous linear ethylene/ α -olefin polymer described by Elston and to conventional Ziegler polymerized heterogeneous linear polyethylene in that both heterogeneous linear and homogeneously linear ethylene polymers have rheological properties such that as the polydispersity index increases, the I_{10}/I_2 value also increases.

The "rheological processing index" (PI) is the apparent viscosity (in kpoise) of a polymer measured by a gas extrusion rheometer (GER). The gas extrusion rheometer is described by M. Shida, R.N. Shroff and L.V. Cancio in Polymer Engineering Science, Vol. 17, No. 11, p. 770 (1977), and in "Rheometers for Molten Plastics" by John Dealy, published by Van Nostrand Reinhold Co. (1982) on pp. 97-99. GER experiments are performed herein at a temperature of 190°C, at nitrogen pressures between 250 to 5500 psig using a 3.81 cm diameter die and a 20:1 L/D rheometer with an entrance angle of 180°. The processing index is measured herein at 3,000 psig.

For the substantially linear ethylene/ α -olefin interpolymers used herein, the PI is the apparent viscosity (in kpoise) of a material measured by GER at an apparent shear stress of 2.15×10^6 dyne/cm². The substantially linear ethylene/ α -olefin interpolymers used herein preferably have a PI in

the range of 0.01 kpoise to 50 kpoise, preferably 15 kpoise or less. The substantially linear ethylene/ α -olefin interpolymers used herein have a PI less than or equal to 70 percent of the PI of a comparative linear ethylene polymer (either a Ziegler polymerized polymer or a linear uniformly
5 branched polymer as described by Elston in US Patent 3,645,992) at about the same I_2 and M_w/M_n .

An apparent shear stress versus apparent shear rate plot can be used to identify the melt fracture phenomena. According to Ramamurthy in the Journal of Rheology, 30(2), 337-357, 1986, above a certain critical flow rate,
10 the observed extrudate irregularities may be broadly classified into two main types: surface melt fracture and gross melt fracture.

Surface melt fracture occurs under apparently steady flow conditions and ranges in detail from loss of specular film gloss to the more severe form of "sharkskin." In this disclosure, the onset of surface melt fracture (OSMF)
15 is characterized at the beginning of losing extrudate gloss at which the surface roughness of the extrudate can only be detected by 40x magnification. The critical shear rate at the onset of surface melt fracture for the substantially linear ethylene/ α -olefin interpolymers is at least 50 percent greater than the critical shear rate at the onset of surface melt fracture of a
20 comparative linear ethylene polymer (either a Ziegler polymerized heterogeneously branched polymer or a homogeneously branched polymer as described by Elston in US Patent 3,645,992) having about the same I_2 and M_w/M_n .

Gross melt fracture occurs at unsteady extrusion flow conditions and
25 ranges in detail from regular (alternating rough and smooth, helical, etc.) to random distortions. For commercial acceptability, (for example, in blown films and bags therefrom), surface defects should be minimal, if not absent, for good film quality and properties. The critical shear rate at the onset of

surface melt fracture (OSMF) and the onset of gross melt fracture (OGMF) will be used herein based on the changes of surface roughness and configurations of the extrudate.

To more fully characterize the rheological behavior of the unique substantially linear ethylene/ α -olefin interpolymers, S. Lai and G.W. Knight introduced (ANTEC '93 Proceedings, INSITE™ Technology Polyolefins (ITP) - New Rules in the Structure/Rheology Relationship of Ethylene α -Olefin Copolymers, New Orleans, La., May 1993) another rheological measurement, the Dow Rheology Index (DRI), which expresses a polymer's "normalized relaxation time as the result of long chain branching." DRI ranges from 0 for polymers which do not have any measurable long chain branching (for example, "TAFMER" and "EXACT" products sold commercially by Mitsui Chemical and Exxon Chemical Company, respectively) to about 15 and is independent of melt index. In general, for low to medium density ethylene polymers (particularly at lower densities) DRI provides improved correlations to melt elasticity and high shear flowability relative to correlations of the same attempted with melt flow ratios. For the substantially linear ethylene/ α -olefin polymers used in this invention, DRI is preferably at least about 0.1, and especially at least about 0.5, and most especially at least 0.8. DRI can be calculated from the equation:

$$DRI = (3652879 * \tau_o^{1.00649} / \eta_o - 1) / 10$$

where τ_o is the characteristic relaxation time of the material and η_o is the zero shear viscosity of the material. Both τ_o and η_o are the "best fit" values to the Cross equation, that is

$$\eta / \eta_o = 1 / (1 + (\dot{\gamma} * \tau_o)^{1-n})$$

where n is the power law index of the material, and η and $\dot{\gamma}$ are the measured viscosity and shear rate, respectively.

Baseline determination of viscosity and shear rate data are obtained using a Rheometric Mechanical Spectrometer (RMS-800) under dynamic sweep mode from 0.1 to 100 radians/second at 160°C and a Gas Extrusion Rheometer (GER) at extrusion pressures from 1,000 psi to 5,000 psi (6.89 to 34.5 MPa), which corresponds to shear stress from 0.086 to 0.43 MPa, using a 3.81 centimeter diameter die and 20:1 L/D rheometer at 190°C. Specific material determinations can be performed from 140 to 190°C as required to accommodate melt index variations.

Substantially linear ethylene/ α -olefin interpolymers are considered to be "homogeneous" in composition distribution since substantially all of the polymer molecules have the same ethylene-to-comonomer ratio. Moreover, the substantially linear ethylene polymers have a narrow short chain (homogeneous) branching distribution, as defined by US Patent 3,645,992. The distribution of comonomer branches for the substantially linear ethylene/ α -olefin interpolymers is characterized by its SCBDI (Short Chain Branch Distribution Index) or CDBI (Composition Distribution Branch Index) and is defined as the weight percent of the polymer molecules having a comonomer content within 50 percent of the median total molar comonomer content. The CDBI of a polymer is readily calculated from data obtained from techniques known in the art, such as, for example, temperature rising elution fractionation (abbreviated herein as "TREF"). The SCBDI or CDBI for the substantially linear ethylene/ α -olefin interpolymers used in the present invention is preferably greater than 30 percent, especially greater than 50 percent.

The substantially linear ethylene/ α -olefin polymers used in this invention essentially lack a measurable "high density" fraction, as measured by the TREF technique. Preferably, the substantially linear

ethylene/ α -olefin interpolymers do not contain a polymer fraction with a degree of branching less than or equal to 2 methyls/1000 carbons. The "high density polymer fraction" can also be described as a polymer fraction with a degree of branching less than 2 methyls/1000 carbons.

- 5 The molecular weight and molecular weight distribution, M_w/M_n ratio, of substantially linear ethylene/ α -olefin interpolymers can be analyzed by gel permeation chromatography (GPC) on a Waters 150 high temperature chromatographic unit equipped with differential refractometer and three columns of mixed porosity. The columns are supplied by
- 10 Polymer Laboratories and are commonly packed with pore sizes of 10^3 , 10^4 , 10^5 and 10^6 \AA . The solvent is 1,2,4-trichlorobenzene, from which 0.3 percent by weight solutions of the samples are prepared for injection. The flow rate is 1.0 milliliters/minute, unit operating temperature is 140°C and the injection size is 100 microliters.
- 15 The molecular weight determination with respect to the polymer back-bone is deduced by using narrow molecular weight distribution polystyrene standards (from Polymer Laboratories) in conjunction with their elution volumes. The equivalent polyethylene molecular weights are determined by using appropriate Mark-Houwink coefficients for
- 20 polyethylene and polystyrene (as described by Williams and Ward in Journal of Polymer Science, Polymer Letters, Vol. 6, p. 621, 1968) to derive the following equation:

$$25 \quad M_{\text{polyethylene}} = a * (M_{\text{polystyrene}})^b.$$

In this equation, $a = 0.4316$ and $b = 1.0$. Weight average molecular weight, M_w , is calculated in the usual manner according to the following formula: $M_w = \sum w_i * M_i$, where w_i and M_i are the weight fraction and

molecular weight, respectively, of the i^{th} fraction eluting from the GPC column.

For the substantially linear ethylene/ α -olefin interpolymers used in the present invention, the M_w/M_n is preferably less than 3, especially from
5 1.5 to 2.5.

The novel film comprises from 5 to 40 weight percent, based on the combined weight of components (A) and (B), of the substantially linear ethylene/ α -olefin interpolymers, preferably from 10 to 35 weight percent, and more preferably from 15 to 30 weight percent.

10 The substantially linear ethylene/ α -olefin interpolymers used to prepared the film of the present invention has an I_2 melt index in the range of 0.3 g/10 minutes to 3 g/10, preferably, 0.3 g/10 minutes to 2.5 g/10 minutes and, more preferably, 0.4 g/10 minutes to 2 g/10 minutes. The substantially linear ethylene/ α -olefin interpolymers has a density less about
15 0.92 g/cc, more preferably, in the range of 0.85 g/cc to 0.916 g/cc, and most preferably, in the range of 0.86 g/cc to 0.91 g/cc. The I_{10}/I_2 ratio of the substantially linear ethylene/ α -olefin interpolymers is in the range from 5.63 to 30, preferably less than about 20, especially less than about 15, and most especially less than about 10.

20 Component (B) can be a blend of substantially linear ethylene/ α -olefin interpolymers or, optionally, a blend of an SLEP interpolymers with at least one heterogeneous or homogeneous linear ethylene polymers selected from the group consisting of ULDPE and LLDPE. When the substantially linear ethylene/ α -olefin interpolymers is employed
25 in such blends, a blend of an SLEP with a heterogeneous ULDPE, component (C), is preferred.

Heterogeneously branched ULDPE and LLDPE are well known and commercially available materials. They are typically prepared using Ziegler-

Natta catalysts in solution or gas phase polymerization processes Anderson et al., U.S. Pat. 4,076,698, is illustrative. These traditional Ziegler-type linear polyethylenes are not homogeneously branched and they do not have any long-chain branching. Heterogeneously branched ULDPE and LLDPE typical
5 having molecular weight distributions, M_w/M_n , in the range of from 3.5 to 4.1.

Homogeneously branched ULDPE and LLDPE are also well known. Elston disclosure in U.S. Pat. 3,645,992 is illustrative. Homogeneously branched ULDPE and LLDPE can be prepared in conventional
10 polymerization processes using Ziegler-type catalysts such as, for example, zirconium and vanadium catalyst systems as well as using metallocene catalyst systems such as, for example, those based on hafnium. Ewen et al. disclosure in U.S. Pat. 4,937,299 and Tsutsui et al. disclosure in U.S. Pat. 5,218,071 are illustrative. This second class of linear polyethylenes are
15 homogeneously branched polymers, and like traditional Ziegler-type heterogeneous linear polyethylenes, they do not have any long-chain branching. Homogeneously branched ULDPE and LLDPE typical having molecular weight distributions, M_w/M_n , of about 2. Commercial examples of homogeneously branched linear polyethylenes include those sold by
20 Mitsui Petrochemical Industries under the designation "TAFMER" and by Exxon Chemical Company under the designation "EXACT".

The preparation of polyethylene film by blown film extrusion is well-known. See, for example, U.S. Patent 4,632,801 by Dowd which described a typical blown film extrusion process. In the typical process, a polyethylene
25 composition is introduced into a screw extruder wherein it is melted and forwarded through the extruder under pressure. The molten polymer composition is forced through an annular film die to form a molten tube. Air is then provided through the annular die to inflate the tube into a

"bubble" with the desired diameter. Air is contained within the bubble by the annular die and nip rollers downstream of the die where thereafter the bubble is collapse into layflat film. The final thickness of the film is controlled by extrusion rate, bubble diameter and nip speed which can be controlled by such variables as screw speed, haul-off rate and winder speed. Increasing the extrusion rate at a constant bubble diameter and nip speed, will increase final film thickness.

The typical blown extrusion process can be generally classified as either "stalk" or "pocket" extrusion. In stalk extrusion, bubble inflation and expansion are controlled or occur at a significant distance above the annular die. The air ring, usually of single-lip construction, provides air flow external to the tube and parallel to the machine direction such that the molten tube maintains the approximate diameter of the annular film die until it is inflated at a height at least 5 inches (12.7 centimeters) above the annular die. Internal bubble cooling can also be used as well as an internal bubble stabilizer to insure optimum bubble stability during fabrication.

Stalk extrusion is known to allow improved molecular relaxation and, as such, mitigates excessive orientation in one direction and thereby allows balanced film physical properties. Increasing the stalk or expansion height generally provides higher cross direction (CD) properties and, thereby, higher average film properties. Stalk extrusion, and particularly high-stalk extrusion, is very useful for preparing blown films from high molecular weight polyethylene compositions such as, for example, high molecular high density polyethylene (HMW-HDPE) and high molecular low density polyethylene (HMW-LDPE) which possess sufficient melt strength to insure adequate bubble stability.

In pocket extrusion, air is supplied by an air ring disposed immediately adjacent to the annular die to cause the bubble leaving the die

to immediately inflate and expand. The air ring is typically a dual-lip type to insure added bubble stability. Pocket extrusion is more widely employed than stalk extrusion and is generally preferred for lower molecular weight, lower melt strength polyethylene compositions such as, for example, linear
5 low density polyethylene (LLDPE) and ultra low density polyethylene (ULDPE).

Both monolayer and multilayer films can be prepared by stalk and pocket extrusion and the films of the present invention can be monolayer or multilayer structures. Multilayer films can be prepared by any known
10 technique in the art, including, for example, coextrusion, lamination or combinations of both. However, the preferred medium modulus, thick polyethylene film of the present invention is a monolayer film structure.

Although the film of this invention can be prepared by variable stalk extrusion, pocket extrusion and low-stalk extrusion are preferred where the
15 high molecular weight linear ethylene polymer, Component (A), has an I_5 melt index greater than about 0.5 g/10 minutes, particularly greater than about 0.6 g/10 minutes, and most particularly greater than about 0.7 g/10 minutes. High stalk extrusion, where the distance between the die and the occurrence of bubble expansion is usually from 30 to 42 inches (76 to 107
20 centimeters), that is, from 6 to 10 die diameters, is preferred for preparing of the film of this invention where the high molecular weight linear ethylene polymer, component (A), has an I_5 melt index less than or equal to about 0.5 g/10 minutes, particularly less than about 0.4 g/10 minutes, and most particularly less than about 0.3 g/10 minutes.

25 Components (A) and (B), and optional Component (C), used to prepare the film of this invention, can be individually blended (that is, where a component itself is a polymer blend of two or more subcomponent polymers) or admixed together by any suitable means known in the art.

Suitable means are thought to include tumble dry-blending the components together prior to charging the blown film extruder, weigh-feeding the components directly into the blown film extruder, melt-blending the components via compound or side-arm extrusion prior to introduction into the blown film extruder, multiple reactor polymerization of the components with reactors in series or in parallel and optionally with different catalyst and/or monomer types in each reactor, or the like as well as combinations thereof.

In addition to the above equations respecting the tear and impact performance of the film of this invention, temperature rising elution fractionation (TREF) can also be used to "fingerprint" or identify the novel film of this invention as well as the film compositions used to make the novel film.

Additives, such as antioxidants (for example, hindered phenolics, such as Irganox® 1010 or Irganox® 1076 supplied by Ciba Geigy), phosphites (for example, Irgafos® 168 also supplied by Ciba Geigy), cling additives (for example, PIB), Standostab PEPQ™ (supplied by Sandoz), pigments, colorants, and fillers can also be included in the film of the present invention, or the polymer compositions used to make the same, to the extent that such additives or ingredients do not interfere with the improved tear and impact resistance performance discovered by Applicants. Although generally not required, the film of the present invention can also contain additives to enhance antiblocking and coefficient of friction characteristics including, but not limited to, untreated and treated silicon dioxide, talc, calcium carbonate, and clay, as well as primary, secondary and substituted fatty acid amides, release agents, silicone coatings, etc. Still other additives, such as quaternary ammonium compounds alone or in combination with ethylene-acrylic acid (EAA) copolymers or other functional polymers, can

also be added to enhance the antistatic characteristics of the film of this invention and allow, for example, heavy-duty packaging of electronically sensitive goods.

Advantageously, because of the improved strength properties of the
5 novel film, recycled and scrap materials as well as diluent polymers can be incorporated or admixed into the film compositions used to make the novel film at higher loadings than is typically possible with prior art polyethylene film compositions and still provide or maintain the desired performance properties for successful use in heavy-duty packaging and shipping
10 applications. Suitable diluent materials include, for example, elastomers, rubbers and anhydride modified polyethylenes (for example, polybutylene and maleic anhydride grafted LLDPE and HDPE) as well as with high pressure polyethylenes such as, for example, low density polyethylene (LDPE), ethylene/acrylic acid (EAA) interpolymers, ethylene/vinyl acetate
15 (EVA) interpolymers and ethylene/methacrylate (EMA) interpolymers, and combinations thereof.

Examples

The following examples illustrate some of the particular embodiments of the present invention, but the following should not be construed to mean the invention is limited only to the particular embodiments shown.

Table 1 lists various resin types for use in investigating the requirements for improved medium modulus films.

Table 1
Resin Types and Properties

Resin Type*	MI g/10 min	Density g/cc	Melt Flow Ratio	M _w /M _n	Critical Shear Rate 1/sec	Critical Shear Stress dyne/cm ²	Comonomer Type	Process Type
HMW-HDPE	0.26 I ₅	0.942	5.5 I _{21.6} /I ₁₀	NA	NA	NA	Butene	Slurry
HMW-HDPE	0.75 I ₅	0.951	NA	NA	NA	NA	Butene	Slurry
HMW-MDPE	0.26 I ₅	0.935	5.3 I _{21.6} /I ₁₀	NA	NA	NA	Butene	Slurry
MDPE	1.0 I ₂	0.935	7.7 I ₁₀ /I ₂	NA	NA	2.4 x 10 ⁶	Octene	Solution
ULDPE	0.8 I ₂	0.905	8.7 I ₁₀ /I ₂	3.8-4.0	NA	3.6 x 10 ⁶	Octene	Solution
LLDPE	1.0 I ₂	0.920	7.6 I ₁₀ /I ₂	3.5-3.8	NA	3.9 x 10 ⁶	Octene	Solution
SLEP	0.8 I ₂	0.911	10.9 I ₁₀ /I ₂	NA	1,044	4.3 x 10 ⁶	Octene	Solution
SLEP	1.0 I ₂	0.870	7.4 I ₁₀ /I ₂	1.98	503	3.0 x 10 ⁶	Octene	Solution
SLEP	0.9 I ₂	0.898	10.8 I ₁₀ /I ₂	2.17	258	2.4 x 10 ⁶	Octene	Solution
SLEP	1.0 I ₂	0.902	7.5 I ₁₀ /I ₂	2.12	NA	4.3 x 10 ⁶	Octene	Solution
SLEP	1.0 I ₂	0.909	9.6 I ₁₀ /I ₂	2.06	1,766	4.5 x 10 ⁶	Octene	Solution
RM-HDPE	0.1 I ₂	0.935	NA	NA	NA	NA	NA	NA

*HMW-HDPE, HMW-HDPE, LLDPE, SLEP and MDPE resins are supplied by The Dow Chemical Company. RM-HDPE denotes a Polybutylene Rubber- Modified HDPE is supplied by Allied-Signal under the designation "PAXON 3208".

Tables 2 - 7 summarize the various component resins and film compositions for use in determining the requirements for medium modulus, polyethylene films with improved strength properties. The tables also summarize the fabrication conditions for use in investigating improved medium modulus, polyethylene film. Except for Inventive Example 43 which involves side-arm extrusion preparation, all blend compositions used in the investigation were performed by tumble-blending

the individual polymer components together according to the weight percentage amounts shown in the various Tables.

Inventive Films 2-4, 6-8 and 10-12 as well as Comparative Films 1, 5, 7, 9 and 13-24 were fabricated by using a seven-zone Kiefel high stalk blown film line equipped with a grooved-barrel extruder, a decompression screw and no internal bubble cooling. Inventive Films 25-28, 34-40, 42 and 43 as well as Comparative Films 29-33 and 41 were fabricated utilizing a conventional pocket blown film line equipped a LLDPE barrier screw. With the exception of Comparative Films prepared from Compositions F and L, which were fabricated using an incline extruder temperature profile, all film fabrications employed a reverse temperature profile. The physical properties of the resultant Inventive Films and Comparative Films from Compositions A - W as a function of thickness are also summarized in Table 2 - 7.

The Tables report both measured and calculated film density. Like calculated film density determinations, the composition I_5 values reported in the tables were also derived from weight-fraction calculations. For purposes of this invention and for component polymers, all reported I_2 values less than 0.5 g/10 minutes and I_5 values greater than 1.0 g/10 minutes are calculated values based on the following relationship:

$$1.0 I_2 = 5.1 I_5.$$

Additionally, for component polymers, reported $I_{21.6}/I_{10}$ values less than 4.0 and I_{10}/I_2 values greater than 15 are also calculated values based on the following relationship:

$$4.4 I_{10}/I_2 = 1.0 I_{21.6}/I_{10}.$$

For purposes of this invention, and as an example, the following computation is the weight-fraction calculation for determining the calculated film density of Inventive Example 1 which comprises 80 weight

percent of a HDPE having a density of 0.942 g/cc and 20 weight percent of a SLEP having a density of 0.902 g/cc:

5 calculated film density (g/cc) = (0.8)(0.942 g/cc) + (0.2)(0.902 g/cc) = 0.934 g/cc .

The following computation example is the weight-fraction calculation for determining the calculated composition I₅ of Inventive Example 25 which comprises 80 weight percent of a HDPE having an I₅ of 0.75 g/10 minutes and 20 weight percent of a SLEP having an I₂ of 1.0 g/10 minutes:

10 calculated composition I₅ (g/10 min.) = (0.8)(0.75 I₅) + (0.2)(1.0 I₂)(5.1 I₅/1.0 I₂) = 1.62 I₅ .

The following computation example is the factor-based calculation for determining the I₅ melt index of the SLEP having a 0.77 g/10 minutes I₂ that used to prepared Composition B:

15 calculated component polymer I₅ (g/10 min.) = (0.77 I₂)(5.1 I₅/1.0 I₂) = 3.93 I₅ .

The following computation example is the factor-based calculation for determining the I_{21.6}/I₁₀ ratio of the SLEP having a 10.9 I₁₀/I₂ ratio that used to prepared Composition B:

20 calculated component polymer I_{21.6}/I₁₀ = (10.9 I₁₀/ I₂)(1.0 I_{21.6}/I₁₀ + 4.4 I₁₀/ I₂) = 2.47 I_{21.6}/ I₁₀.

The following computation example is the normalization calculation for determining the tear strength of Inventive Example 10 at 3 mils where the tear strength is 762 grams at 2.94 mils:

25 tear strength at 3 mils (grams) = (762 g)(3.0 mils/2.94 mils) = 777 grams .

Table 2
Film Compositions, Fabrication Conditions and Film Properties

COMPOSITION	A				B			
INVENTIVE EXAMPLE	1*	2	3	4	5*	6	7	8
COMPONENT (A)								
Type	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE
Polymerization Process	Slurry	Slurry	Slurry	Slurry	Slurry	Slurry	Slurry	Slurry
Comonomer	Butene	Butene	Butene	Butene	Butene	Butene	Butene	Butene
I ₅ , grams/10 minutes	0.26	0.26	0.26	0.26	0.26	0.26	0.26	0.26
I ₂ , grams/10 minutes	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05
Density, g/cc	0.942	0.942	0.942	0.942	0.942	0.942	0.942	0.942
I _{21.6} /I ₁₀	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5
I ₁₀ /I ₂	24.2	24.2	24.2	24.2	24.2	24.2	24.2	24.2
COMPONENT (B)								
Type	SLEP	SLEP	SLEP	SLEP	SLEP	SLEP	SLEP	SLEP
Polymerization Process	Solution	Solution	Solution	Solution	Solution	Solution	Solution	Solution
Comonomer	Octene	Octene	Octene	Octene	Octene	Octene	Octene	Octene
I ₅ , grams/10 minutes	5.1	5.1	5.1	5.1	3.9	3.9	3.9	3.9
I ₂ , grams/10 minutes	1.00	1.00	1.00	1.00	0.77	0.77	0.77	0.77
Density, g/cc	0.902	0.902	0.902	0.902	0.911	0.911	0.911	0.911
I _{21.6} /I ₁₀	1.7	1.7	1.7	1.7	2.5	2.5	2.5	2.5
I ₁₀ /I ₂	7.5	7.5	7.5	7.5	10.9	10.9	10.9	10.9
(A)/(B) BLEND WT. percent	80/20	80/20	80/20	80/20	80/20	80/20	80/20	80/20
FABRICATION CONDITIONS								
Annular Die Diameter, mm	113	113	113	113	113	113	113	113
Extruder Diameter, mm	70	70	70	70	70	70	70	70
Extruder Length/Diameter	24/1	24/1	24/1	24/1	24/1	24/1	24/1	24/1
Die Gap, mm	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2
Output, kg/hr	77	100	100	100	100	100	100	100
Blow-Up Ratio	3.3/1	3.3/1	3.3/1	3.3/1	3.3/1	3.3/1	3.3/1	3.3/1
Stalk Height, cm	104	104	104	104	104	104	104	104
Target Melt Temperature, °C	213	213	213	213	213	213	213	213
PHYSICAL PROPERTIES								
Film Thickness, mils	0.48	3.00	5.10	8.14	0.60	2.21	3.70	5.09
Cal. Film Density, g/cc	0.934	0.934	0.934	0.934	0.935	0.935	0.935	0.935
Composition I ₅ , g/10 min.	1.20	1.20	1.20	1.20	0.71	0.71	0.71	0.71
CD Tear, grams	105	801	1205	>1600	127	763	799	816
MD Tear, grams	11	642	1253	>1600	8	199	499	777
Tear Strength, grams	58	722	1229	>1600	68	481	649	797

*Denotes Comparative Examples only, that is, the examples are not examples of the present invention.
 Cal. Film Density denotes calculated film density.

5

10

15

Table 3
Film Compositions, Fabrication Conditions and Film Properties

COMPOSITION	C				D			
EXAMPLE	9*	10	11	12	13*	14*	15*	16*
COMPONENT (A)								
Type	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE
Polymerization Process	Slurry	Slurry	Slurry	Slurry	Slurry	Slurry	Slurry	Slurry
Comonomer	Butene	Butene	Butene	Butene	Butene	Butene	Butene	Butene
I ₅ , grams/10 minutes	0.26	0.26	0.26	0.26	0.26	0.26	0.26	0.26
I ₂ , grams/10 minutes	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05
Density, g/cc	0.942	0.942	0.942	0.942	0.935	0.935	0.935	0.935
I _{21.6} /I ₁₀	5.5	5.5	5.5	5.5	5.25	5.25	5.25	5.25
I ₁₀ /I ₂	24.2	24.2	24.2	24.2	23.1	23.1	23.1	23.1
COMPONENT (B)								
Type	ULDPE	ULDPE	ULDPE	ULDPE	None	None	None	None
Polymerization Process	Solution	Solution	Solution	Solution	-	-	-	-
Comonomer	Octene	Octene	Octene	Octene	-	-	-	-
I ₅ , grams/10 minutes	4.1	4.1	4.1	4.1	-	-	-	-
I ₂ , grams/10 minutes	0.8	0.8	0.8	0.8	-	-	-	-
Density, g/cc	0.905	0.905	0.905	0.905	-	-	-	-
I _{21.6} /I ₁₀	2.0	2.0	2.0	2.0	-	-	-	-
I ₁₀ /I ₂	8.7	8.7	8.7	8.7	-	-	-	-
COMPONENT (C)								
Type	SLEP	SLEP	SLEP	SLEP	None	None	None	None
Polymerization Process	Solution	Solution	Solution	Solution	-	-	-	-
Comonomer	Octene	Octene	Octene	Octene	-	-	-	-
I ₅ , grams/10 minutes	3.9	3.9	3.9	3.9	-	-	-	-
I ₂ , grams/10 minutes	0.77	0.77	0.77	0.77	-	-	-	-
Density, g/cc	0.911	0.911	0.911	0.911	-	-	-	-
I _{21.6} /I ₁₀	2.5	2.5	2.5	2.5	-	-	-	-
I ₁₀ /I ₂	10.9	10.9	10.9	10.9	-	-	-	-
(A)/(B)/(C) BLEND WT. percent	80/10/10	80/10/10	80/10/10	80/10/10	100/0/0	100/0/0	100/0/0	100/0/0
FABRICATION CONDITIONS								
Annular Die Diameter, mm	113	113	113	113	113	113	113	113
Extruder Diameter, mm	70	70	70	70	70	70	70	70
Extruder Length/Diameter	24/1	24/1	24/1	24/1	24/1	24/1	24/1	24/1
Die Gap, mm	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2
Output, kg/hr	77	100	100	100	77	100	100	100
Blow-Up Ratio	3.3/1	3.3/1	3.3/1	3.3/1	3.3/1	3.3/1	3.3/1	3.3/1
Stalk Height, cm	104	104	104	104	104	104	104	104
Melt Temperature, °C	213	213	213	213	213	213	213	213
PHYSICAL PROPERTIES								
Film Thickness, mils	0.50	2.94	4.76	7.76	0.55	2.88	5.1	6.17
Cal. Film Density, g/cc	0.935	0.935	0.935	0.935	0.935	0.935	0.935	0.935
Composition I ₅ , g/10 min.	0.71	0.71	0.71	0.71	0.26	0.26	0.26	0.26
CD Tear, grams	141	1120	1471	>1600	95	573	828	1100
MD Tear, grams	10	404	923	>1600	9	306	726	969
Tear Strength, grams	76	762	1197	>1600	52	440	777	1035

5 *Denotes Comparative Examples only, that is, the examples are not examples of the present invention.
 Cal. Film Density denotes calculated film density.

Table 4
Film Compositions, Fabrication Conditions and Film Properties

5

COMPOSITION					F			
EXAMPLE	17*	18*	19*	20*	21*	22*	23*	24*
COMPONENT (A)								
Type	HDPE	HDPE	HDPE	HDPE	MDPE	MDPE	MDPE	MDPE
Polymerization Process	Slurry	Slurry	Slurry	Slurry	Solution	Solution	Solution	Solution
Comonomer	Butene	Butene	Butene	Butene	Octene	Octene	Octene	Octene
I ₅ , grams/10 minutes	0.26	0.26	0.26	0.26	5.1	5.1	5.1	5.1
I ₂ , grams/10 minutes	0.05	0.05	0.05	0.05	1.0	1.0	1.0	1.0
Density, g/cc	0.942	0.942	0.942	0.942	0.935	0.935	0.935	0.935
I _{21.6} /I ₁₀	5.5	5.5	5.5	5.5	1.8	1.8	1.8	1.8
I ₁₀ /I ₂	24.2	24.2	24.2	24.2	7.7	7.7	7.7	7.7
COMPONENT (B)								
Type	None	None	None	None	None	None	None	None
Polymerization Process	-	-	-	-	-	-	-	-
Comonomer	-	-	-	-	-	-	-	-
I ₅ , grams/10 minutes	-	-	-	-	-	-	-	-
I ₂ , grams/10 minutes	-	-	-	-	-	-	-	-
Density, g/cc	-	-	-	-	-	-	-	-
I _{21.6} /I ₁₀	-	-	-	-	-	-	-	-
I ₁₀ /I ₂	-	-	-	-	-	-	-	-
(A)/(B) BLEND WT. percent	100/0	100/0	100/0	100/0	100/0	100/0	100/0	100/0
FABRICATION CONDITIONS								
Annular Die Diameter, mm	113	113	113	113	152	152	152	152
Extruder Diameter, mm	70	70	70	70	64	64	64	64
Extruder Length/Diameter	24/1	24/1	24/1	24/1	24/1	24/1	24/1	24/1
Die Gap, mm	1.2	1.2	1.2	1.2	1.6	1.6	1.6	1.6
Output, kg/hr	77	100	100	100	64	64	64	64
Blow-Up Ratio	3.3/1	3.3/1	3.3/1	3.3/1	2.5/1	2.5/1	2.5/1	2.5/1
Stalk Height, cm	104	104	104	104	<12.7	<12.7	<12.7	<12.7
Target Melt Temperature, °C	213	213	213	213	213	213	213	213
PHYSICAL PROPERTIES								
Film Thickness, mils	0.86	2.78	4.73	7.32	0.62	2.86	3.48	8.22
Cal. Film Density, g/cc	0.942	0.942	0.942	0.942	0.935	0.935	0.935	0.935
Composition I ₅ , g/10 min.	0.26	0.26	0.26	0.26	5.1	5.1	5.1	5.1
CD Tear, grams	89	263	454	931	323	441	556	1359
MD Tear, grams	28	224	514	1054	31	305	333	1027
Tear Strength, grams	59	244	484	993	177	373	445	1193
Impact Resistance, gram	NA	NA	NA	NA	50	165	185	505

*Denotes Comparative Examples only, that is, the examples are not examples of the present invention. Cal. Film Density denotes calculated film density.

10

Table 5
Film Compositions, Fabrication Conditions and Film Properties

COMPOSITION	G	H	I	J	K	L	M	N	O
EXAMPLE	25	26	27	28	29*	30*	31*	32*	33*
COMPONENT (A)									
Type	HDPE	HDPE	HDPE	HDPE	None	MDPE	HDPE	None	HDPE
Polymerization Process	Slurry	Slurry	Slurry	Slurry	-	Solution	Slurry	-	Slurry
Comonomer	Butene	Butene	Butene	Butene	-	Octene	Butene	-	Butene
I ₅ , g/10 min.	0.75	0.75	0.75	0.75	-	5.1	0.75	-	0.3
I ₂ , g/10 min.	0.15	0.15	0.15	0.15	-	1.0	0.15	-	-
Density, g/cc	0.951	0.951	0.951	0.951	-	0.935	0.951	-	0.950
I ₁₀ /I ₂	NA	NA	NA	NA	-	7.7	NA	-	24
COMPONENT (B)									
Type	SLEP	SLEP	SLEP	SLEP	SLEP	None	None	LLDPE	None
Polymerization Process	Solution	Solution	Solution	Solution	Solution	-	-	Solution	-
Comonomer	Octene	Octene	Octene	Octene	Octene	-	-	Octene	-
I ₅ , g/10 min.	5.1	5.1	5.1	5.1	5.1	-	-	5.1	-
I ₂ , g/10 min.	1.0	1.0	1.0	1.0	1.0	-	-	1.0	-
Density, g/cc	0.870	0.870	0.870	0.870	0.870	-	-	0.920	-
I ₁₀ /I ₂	7.4	7.4	7.4	7.4	7.4	-	-	7.6	-
(A)/(B) BLEND WT. percent	80/20	75/25	85/15	90/10	0/100	100/0	100/0	0/100	100/0
FABRICATION CONDITIONS									
Annular Die Diameter, mm	152	203	203	152	152	152	152	152	113
Extruder Diameter, mm	64	89	89	64	64	64	64	64	70
Extruder Length/Diameter	24/1	30/1	30/1	24/1	24/1	24/1	24/1	24/1	24/1
Die Gap, mm	1.6	2.8	2.8	1.6	1.6	1.6	1.6	1.6	1.2
Output, kg/hr	64	68	68	42	31	64	64	64	100
Blow-Up Ratio	2.5/1	2.5/1	2.5/1	2.0/1	2.0/1	2.5/1	2.5/1	2.5/1	3.3/1
Stalk Height, cm	<12.7	<12.7	<12.7	<12.7	<12.7	<12.7	<12.7	<12.7	104
Viton Processing Aid	None	None	None	None	None	Yes	None	None	None
Extruder Amps	58	NA	NA	58	NA	71	58	65	NA
Melt Temperature, °C	229	236	236	238	229	226	235	225	NA
Die Pressure, psi	3170	3450	3450	4650	4170	3170	3420	3130	NA
PHYSICAL PROPERTIES									
Film Thickness, mils	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
Meas. Film Density, g/cc	0.934	0.936	0.943	0.941	0.870	0.935	0.951	0.92	0.950
Composition I ₅ , g/10 min.	1.6	1.8	1.4	1.2	5.1	5.1	0.75	5.1	0.30
CD Tear, grams	324	1391	1826	464	91	328	80	1558	228
MD Tear, grams	1419	362	126	110	62	593	284	>1600	125
Tear Strength, grams	872	876	976	287	77	461	182	1580	177
Impact Resistance, grams	425	432	198	185	>850	250	125	800	NA

*Denotes Comparative Examples only, that is, the examples are not examples of the present invention. Meas. Film Density denotes measured film density. NA denotes data not available. Viton is a fluoropolymer processing aid supplied by Dupont Chemical Company.

Table 6
Film Compositions, Fabrication Conditions and Film Properties

COMPOSITION	P	Q	R	S	T	U	V	W
EXAMPLE	34	35	36	37	38	39	40	41*
COMPONENT (A)								
Type	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE	HDPE	RM-HDPE
Polymerization Process	Slurry	Slurry	Slurry	Slurry	Slurry	Slurry	Slurry	Rubber
Comonomer (or Rubber Type)	Butene	Butene	Butene	Butene	Butene	Butene	Butene	Polybutylene
I ₅ g/10 min.	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.51
I ₂ g/10 min.	0.15	0.15	0.15	0.15	0.15	0.15	0.15	0.10
Density, g/cc	0.951	0.951	0.951	0.951	0.951	0.951	0.951	0.935
I ₁₀ /I ₂	NA	NA	NA	NA	NA	NA	NA	NA
COMPONENT (B)								
Type	ULDPE	ULDPE	SLEP	SLEP	SLEP	SLEP	SLEP	None
Polymerization Process	Solution	Solution	Solution	Solution	Solution	Solution	Solution	-
Comonomer	Octene	Octene	Octene	Octene	Octene	Octene	Octene	-
I ₅ g/10 min.	4.1	4.1	4.6	4.6	5.1	5.1	4.6	-
I ₂ g/10 min.	0.8	0.8	0.9	0.9	1.0	1.0	0.9	-
Density, g/cc	0.905	0.905	0.898	0.898	0.909	0.909	0.898	-
I ₁₀ /I ₂	8.7	8.7	10.8	10.8	9.6	9.6	10.8	-
COMPONENT (C)								
Type	None	None	None	None	None	None	ULDPE	None
Polymerization Process	-	-	-	-	-	-	Solution	-
Comonomer	-	-	-	-	-	-	Octene	-
I ₅ g/10 min.	-	-	-	-	-	-	4.1	-
I ₂ g/10 min.	-	-	-	-	-	-	0.8	-
Density, g/cc	-	-	-	-	-	-	0.905	-
I ₁₀ /I ₂	-	-	-	-	-	-	8.7	-
(A)/(B)/(C) BLEND WT. percent	90/10/0	80/20/0	90/10/0	80/20/0	90/10/0	80/20/0	80/10/10	100/0
FABRICATION CONDITIONS								
Annular Die Diameter, mm	152	152	152	152	152	152	152	152
Extruder Diameter, mm	64	64	64	64	64	64	64	64
Extruder Length/Diameter	24/1	24/1	24/1	24/1	24/1	24/1	24/1	24/1
Die Gap, mm	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6
Output, kg/hr	31	31	31	31	31	31	31	31
Blow-Up Ratio	2.0/1	2.0/1	2.0/1	2.0/1	2.0/1	2.0/1	2.0/1	2.0/1
Stalk Height, cm	<12.7	<12.7	<12.7	<12.7	<12.7	<12.7	<12.7	<12.7
Target Melt Temperature, °C	229	229	229	229	229	229	229	229
Die Pressure, psi	4170	4170	4170	4170	4170	4170	4170	4170
PHYSICAL PROPERTIES								
Film Thickness, mils	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
Meas. Film Density, g/cc	0.944	0.941	0.950	0.940	0.945	0.942	0.941	0.934
Composition I ₅ g/10 min.	1.1	1.4	1.1	1.5	1.2	1.6	1.5	0.51
CD Tear, grams	322	411	318	506	266	328	312	544
MD Tear, grams	115	138	114	131	94	112	110	110
Tear Strength, grams	219	275	216	319	180	220	211	327
Impact Resistance, grams	175	173	164	175	163	164	164	403

*Denotes Comparative Examples only, that is, the examples are not examples of the present invention.

Meas. Film Density denotes measured film density. NA denotes data not available. RM-HDPE denotes PAXON 3208 polybutylene rubber modified HDPE.

Table 7
Effect of Stalk Height on Impact Properties

COMPOSITION	G [†]	G [†]
EXAMPLE	42	43
COMPONENT (A)		
Type	HDPE	HDPE
Polymerization Process	Slurry	Slurry
Comonomer	Butene	Butene
I ₅ , g/10 min.	0.75	0.75
I ₂ , g/10 min.	0.15	0.15
Density, g/cc	0.951	0.951
I ₁₀ /I ₂	NA	NA
COMPONENT (B)		
Type	SLEP	SLEP
Polymerization Process	Solution	Solution
Comonomer	Octene	Octene
I ₅ , g/10 min.	5.1	5.1
I ₂ , g/10 min.	1.0	1.0
Density, g/cc	0.870	0.870
I ₁₀ /I ₂	7.4	7.4
(A)/(B) BLEND WT. percent	80/20	80/20
FABRICATION CONDITIONS		
Annular Die Diameter, mm	152	152
Extruder Diameter, mm	64	64
Extruder Length/Diameter	24/1	24/1
Die Gap, mm	2.8	2.8
Output, kg/hr	64	64
Blow-Up Ratio	2.5/1	2.5/1
Stalk Height, cm	<12.7	102
Frost Line Height, cm	76	127
Target Melt Temperature, °C	232	232
PHYSICAL PROPERTIES		
Film Thickness, mils	3.0	3.0
Meas. Film Density, g/cc	0.934	0.934
Impact Resistance, grams	400	425

*Denotes Comparative Examples only, that is, the examples are not examples of the present invention. Meas. Film Density denotes measured film density. NA denotes data not available.

[†]Denotes Composition G is prepared in a commercial-scale slurry polymerization manufacturing plant by side-arm extrusion incorporation of the substantially linear ethylene/ α -olefin interpolymers.

The physical property data in Tables 2 - 7 and Figures 2 - 4 demonstrate that films prepared in accordance with the present invention exhibit substantially improved tear strength and impact resistance in comparisons with other films prepared from individual component polymers that have the same film density, film thickness and similar melt

index. The tables also show Inventive Films exhibit superior tear strength and impact resistance over PAXON 3208 (Comparative Example 41), a polybutylene rubber modified HDPE used commercially for a variety of heavy-duty packaging applications. The superior performance of the
5 Inventive Films of the present invention allow practitioners down-gauging savings while still providing polyethylene films that meet the demanding requirements of heavy-duty packaging.

Figure 2 specifically illustrates that Inventive Films prepared from Composition A, B and C exhibit superior tear strength at film thicknesses
10 greater than 1.25 mils (31 microns), particularly in the range of 1.5 to 8.75 mils, and especially in the range of 2 mils to 8 mils in comparison to Comparative Films prepared from Compositions D, E and F.

Figure 2 also shows Inventive Films comprising Components (A) and (B) as well as those comprising Components (A), (B) and (C) as three-
15 component blends, exhibit exceptional comparative tear performance. A comparison between the Inventive Films prepared using Compositions B and C indicates a substantially linear ethylene/ α -olefin interpolymers, Component (B), having an I_{10}/I_2 ratio less than about 10 is most preferred for film thicknesses greater than about 3 mils. In direct comparisons,
20 Inventive Films show from 30 percent greater tear strength at 3 mils (comparison between films based on Compositions B and D) to as high as about 180 percent greater tear strength at 5 mils (comparison between films based on Compositions C and E).

Figure 3 shows at equivalent densities, Inventive Films (Inventive
25 Examples 25-28 and 34-38) exhibit superior impact resistance at 3 mils over Comparative Films (Comparative Examples 22 and 30-32 where Comparative Examples 22 and 30 are averaged and plotted as a single data point). Figure 3 also indicates Inventive Examples 25 and 26 show more

than 100 percent greater impact resistance than is ordinarily expected for their respective measured densities. These Inventive Films also indicate that substantially linear ethylene/ α -olefin interpolymers, Component (B), having densities less than 0.89 g/cc are most preferred for preparing the
5 novel film of the present invention.

Figure 4 illustrates Inventive Examples 25, 26 and 27 exhibit synergistically superior tear strength relative to predicated or calculated performance based on their respective component polymers, a 0.951 g/cc HMW-HDPE and a 0.87 g/cc SLEP at 100 percent/0 percent, 90 percent/10
10 percent, 80 percent/20, 70 percent/30 percent and 0 percent/100 percent, respectively. Figure 4 also shows that Inventive Films can exhibit more than about 90 percent greater tear strength than comparative films having about the same melt index, film thickness and measured film density.

Table 7 specifically indicates, although low-stalk and pocket extrusion
15 are preferred for fabricating Inventive Film comprising a Component (A) polymer having a I_5 greater than 0.5 g/10 minutes, Inventive Films can also be successfully fabricated using variable-stalk extrusion, that is pocket and stalk extrusion. Even more surprisingly, is these Inventive Examples indicate the novel film can be fabricated with a high-stalk on conventional
20 pocket extrusion lines. This feature of the invention allows Practitioners the significant commercial benefits of equipment selection flexibility and equipment utilization efficiency.

1. A medium modulus, polyethylene film characterized as having a thickness greater than about 1.25 mils which comprises:

(A) from 60 to 95 weight percent, based on the combined weight of components (A) and (B), of at least one high molecular weight linear ethylene polymer having a density in the range of 0.92 to 0.96 g/cc and an I_5 melt index in the range of 0.1 to 3 g/10 minutes, and

(B) from 5 to 40 weight percent, based on the combined weight of components (A) and (B), of at least one substantially linear ethylene/ α -olefin interpolymer characterized as having:

- i. a melt flow ratio, $I_{10}/I_2 \geq 5.63$, and
- ii. a molecular weight distribution, M_w/M_n , defined by the equation:

$$M_w/M_n \leq (I_{10}/I_2) - 4.63$$

wherein the substantially linear ethylene/ α -olefin polymer is further characterized as containing at least one α -olefin monomer and having a density in the range of 0.85 to 0.92 g/cc and an I_2 melt index in the range of 0.3 to 3 g/10 minutes, wherein said film is further characterized as having a tear strength at least 30 percent greater than the tear strength of a comparative polyethylene film having essentially the same density, thickness and melt index.

2. The film of Claim 1 wherein said film is a blown film.

3. The film of Claim 1 wherein the film thickness is in the range of 1.5 mils to 8.75 mils.

4. The film of Claim 3 wherein the film thickness is in the range of 2 to 8 mils.

5. The film of Claim 1 wherein the calculated film density is in the range of 0.923 g/cc to 0.95 g/cc.

6. The film of Claim 1 wherein said high molecular weight linear ethylene polymer is an interpolmer of ethylene and at least one α -olefin selected from the group consisting of 1-propylene, 1-butene, 4-methyl-1-pentene, 1-hexene and 1-octene.

7. The film of Claim 6 wherein said high molecular weight linear ethylene interpolmer is a copolymer of ethylene and 1-butene.

8. The film of Claim 1 wherein said substantially linear ethylene/ α -olefin polymer is further characterized as having:

iii. a critical shear rate at onset of surface melt fracture at least 50 percent greater than the critical shear rate at onset of surface melt fracture of a comparative linear ethylene polymer having about the same I_2 and M_w/M_n .

9. The film of Claim 1 wherein said substantially linear ethylene/ α -olefin polymer is further characterized as having from 0.01 long chain branches/1000 carbons to 3 long chain branches/1000 carbons along the polymer backbone.

10. The film of Claim 1 wherein said substantially linear ethylene/ α -olefin polymer is an interpolmer of ethylene and at least one α -olefin selected from the group consisting of 1-propylene, 1-butene, 4-methyl-1-pentene, 1-hexene and 1-octene.

11. The film of Claim 10 wherein said substantially linear ethylene/ α -olefin interpolmer is a copolymer of ethylene and 1-octene.

12. The film of Claim 1 wherein said high molecular weight linear ethylene polymer has an I_5 melt index in the range of 0.1 g/10 minutes to 2 g/10 minutes.

13. The film of Claim 1 wherein said substantially linear ethylene polymer has an I₂ melt index in the range of 0.3 g/10 minutes to 2.5 g/10 minutes.

5 14. The film of Claim 1 wherein said high molecular weight linear ethylene polymer has a density in the range of 0.93 g/cc to 0.96 g/cc.

10 15 The film of Claim 1 wherein said substantially linear ethylene polymer has a density in the range of 0.855 g/cc to 0.918 g/cc.

16. A method for preparing a medium modulus, polyethylene film comprising the steps of:

- 15 (1) providing an extrudable thermoplastic composition containing (A) from 60 to 95 weight percent, based on the combined weight of components (A) and (B), of at least one high weight molecular linear ethylene polymer having a density in the range of 0.92 to 0.96 g/cc and an I₅ melt index in the range of 0.1 to 3 g/10 minutes, and (B) from 5 to 40 weight percent, based on the combined weight of components (A) and (B), of at least one substantially linear ethylene/ α -olefin polymer containing at least one α -olefin and having a density in the range of 0.85 to 0.92 g/cc and an I₂ melt index in the range of 0.3 to 3 g/10 minutes.
- 20 (2) introducing said composition of step (1) into a heated film extrusion apparatus equipped with an annular die,
- 25 (3) extruding said composition through said annular die to form a molten or semi-molten thermoplastic tube of said composition that is subsequently blown-up beyond the die diameter and drawn-down through nip and take-off rollers to form a layflat
- 30

film with a thickness greater than about 1.25 mils (31 microns),
and

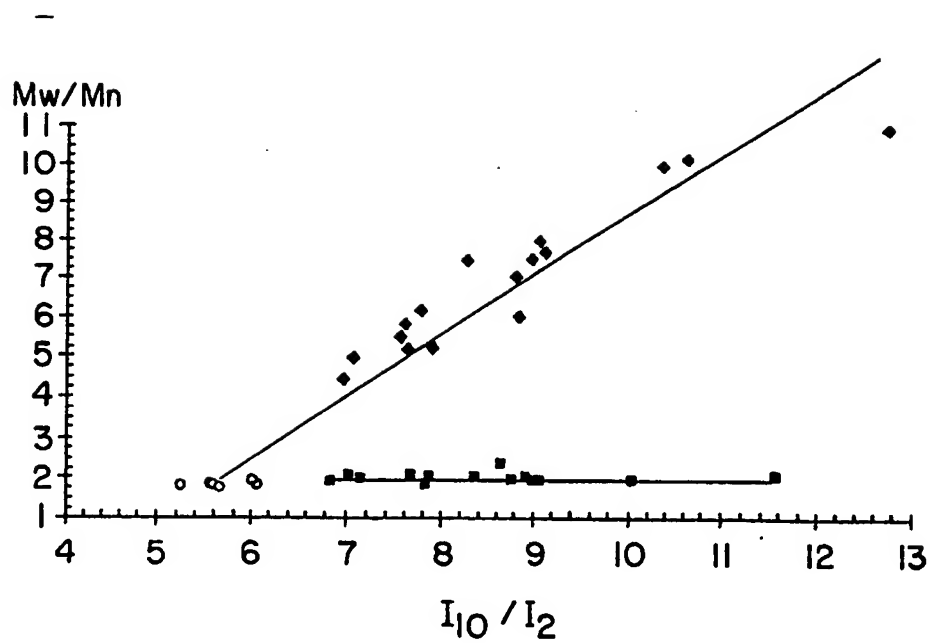
- 5 (4) conveying said film formed in step (3) for subsequent use
down-line of the blown film extrusion apparatus of step (2) or
collecting said film formed in step (3) for subsequent use off-
line,

wherein said film is characterized as having a tear strength at least 30
percent greater than the tear strength of a comparative polyethylene film
10 having essentially the same density, thickness and melt index.

17. The method of Claim 16 wherein said extrusion apparatus is a
variable stalk extrusion film line.

- 15 18. The film produced by the method of Claim 17.

FIG. 1



- ♦ Linear Heterogenous Polymer
- Substantially Linear Polymer
- Linear Homogeneous Polymer

FIG. 2

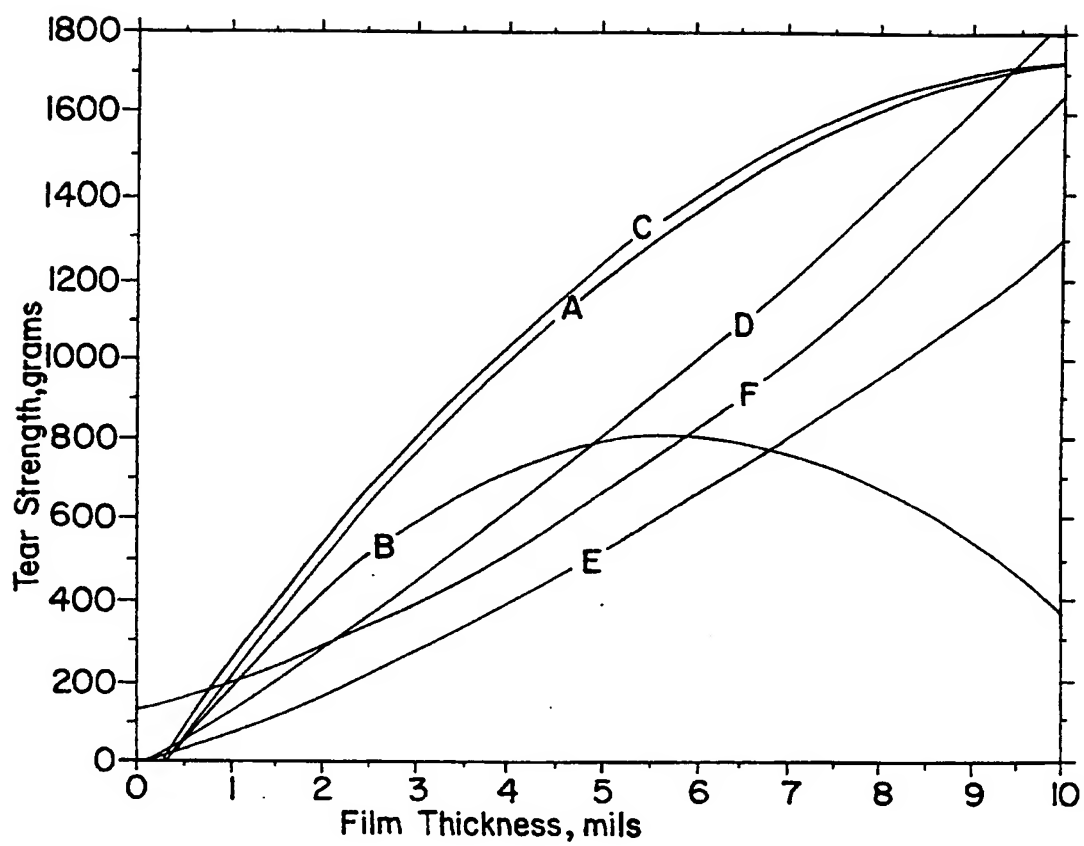
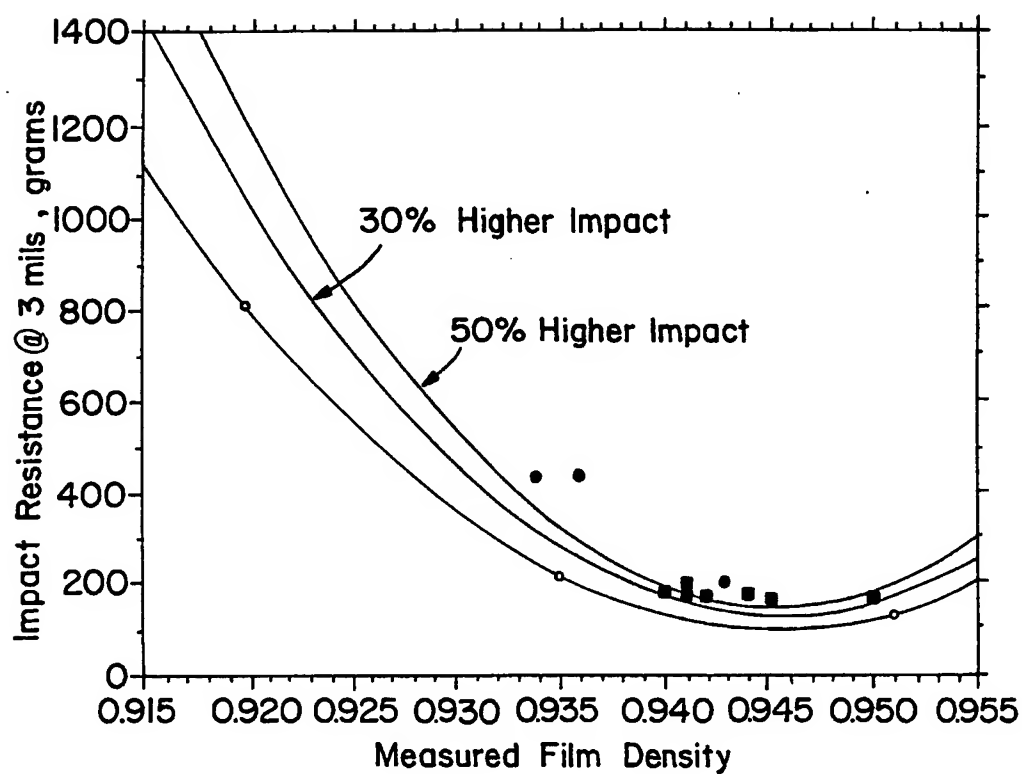
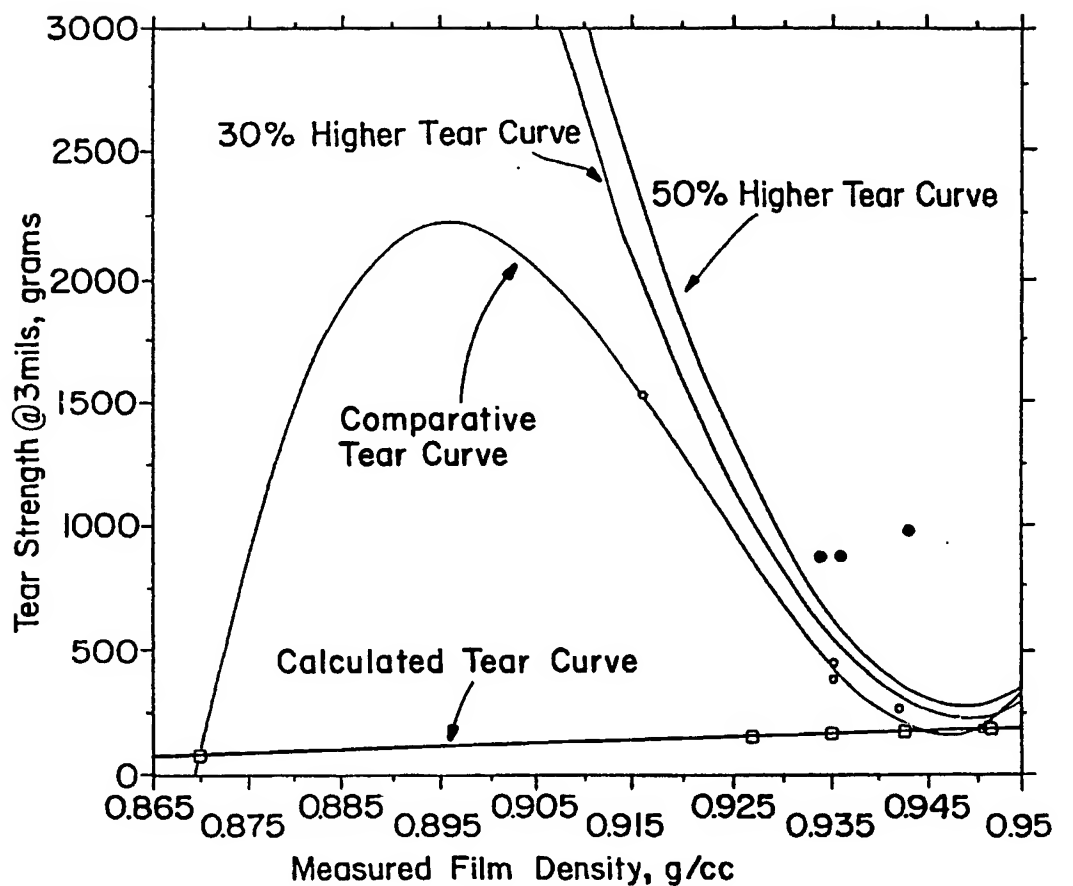


FIG. 3



- Inventive Films (Examples 25-27)
- Inventive Films (Examples 28 & 34-38)
- Comparative Films (Examples 22, 30, 31 & 32)

FIG. 4



- Inventive Films (Examples 25, 26 & 27)
- Comparative Films (Examples 18, 22, 29, 30, 31, 32 & 33)
- ◻ Calculated or Predicted Film

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US 95/05757

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 C08L23/06 C08L23/04 C08J5/18

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 6 C08L C08J

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US,A,4 770 912 (FURRER ET AL.) 13 September 1988 see claims	1-18
A	US,A,4 632 801 (DOWD) 30 December 1986 cited in the application see claims	1-18

☐ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents :

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- * "O" document referring to an oral disclosure, use, exhibition or other means
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- * "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
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Date of the actual completion of the international search

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

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Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US-A-4770912	13-09-88	NONE	
US-A-4632801	30-12-86	CA-A- 1250402	28-02-89
		CA-A- 1239261	19-07-88
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